

Work Order ID: 107494

Thursday, September 26, 2013 10:06:40 AM

\*107494\*

Page 1

Item ID: D3322-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Pod Assembly  
 Start Date: 9/26/2013 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 10/4/2013 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: WFE Date: 13-9-26 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2202	REV G								
D3322	Rev A								

100 PURCHASING 0.00  
 \*100\*  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 21515  
 Description: D2202-1 Pod Lid D2202-5 Pod Base  
 Supplier: Delastek  
 Copy of Certificate of Conformity and Process sheet from Delastek is required  
 SHIP TO DELASTEK QTY (1) D3048-1  
 QTY (3) D3001-1 - 1 -

CL 13/09/27 (1)

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
 \*110\*  
 Packaging Memo 0.00  
 Packaging Ensure certificate of conformity and process sheet from Delastek is attached

13/10/14 (1)

QA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



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Doc/Data									
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# Work Order ID 107494

\*107494\*

Page 3

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 Revision ID: Stop \*NS2\*  
 Item Name: Pod Assembly  
 Start Date: 9/26/2013 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 10/4/2013 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
*150*									
Packaging	Memo	0.00							DAS 6 9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

12/11/7  
 14-01-7

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

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# Picklist Print

Thursday, September 26, 2013 10:06:38 A

Page 1

Work Order ID: 107494

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/26/2013

Required Date: 10/4/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD62ABS rivet		Purchased	No			130	Each	62.0000	38	38			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					DAS 28 9-89	13-12-27
				ST278		62				127048			
				125293		62							
AD64ABS Pop Rivets		Purchased	No			130	Each	146.0000	43	43			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					DAS 28 9-89	
				ST278		146							
				123969		89				43x			
				125147		57							
AD66ABS Pop Rivet		Purchased	No			130	Each	232.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					DAS 28 9-89	
				ST278		232							
				112784		232				2x			
AN4-5A BOLT		Purchased	No			130	Each	251.0000	19	19			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					DAS 28 9-89	
				ST355		98							
				120562		98				19x			
				ST514		153							
				120562		153							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
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### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Thursday, September 26, 2013 10:06:39 A

Page 2

Work Order ID: 107494  
Parent Item: D3322-041  
Parent Item Name: Pod Assembly

Start Date: 9/26/2013

Required Date: 10/4/2013

Start Qty: 1.00

Required Qty: 1.00

AN4-6A BOLT	Purchased	No	130	Each	1,616.0000	1	1	DAS 28 9.89	13-12-27
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST504	1300					
			M126317	1300		1X			
			ST514	316					
			123355	30					
			M126175	286					
AN526C632R7 Screw	Purchased	No	130	Each	145.0000	2	2	DAS 28 9.89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST345	145					
			112385	84		2X			
			117317	61					
AN960JD416 Washer	Purchased	No	130	Each	0.0000	21	21	DAS 28 9.89	
D2202-1P Side Pod Lid, 350	Purchased	No	110	Each	0.0000	1	1	107494	
D2202-5P Side Pod, Base 350	Purchased	No	110	Each	0.0000	1	1	107494	
D2204-9 Rubber Latches	Manufactured	No	130	Each	19.0000	5	5	DAS 28 9.89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			st239	19		B107654			
			85081	19					
D2429-041 Spring Clip Ass'Y	Manufactured	No	130	Each	5.0000	1	1	DAS 28 9.89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST010	5		1X			
			81895	5					

Thursday, September 26, 2013 10:06:39 AM

Shop Packet Print

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Thursday, September 26, 2013 10:06:39 A

Page 3

Work Order ID: 107494

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/26/2013

Required Date: 10/4/2013

Start Qty: 1.00

Required Qty: 1.00

D2462 Manufactured No

Seal \$Per Foot

130 f

396.4654

14.17

14.17

DAS

28

9-89

13-12-27

Location

Loc Qty

Loc Code

ST403

396.4654

48530

13.7336

98802

382.7318

170.11

D2528-1

Backer Plate

Manufactured No

130 Each

21.0000

5

5

DAS

28

9-89

Location

Loc Qty

Loc Code

ST011

21

82334

21

135-128  
5X

D2528-3

Backer Plate

Manufactured No

130 Each

6.0000

4

4

DAS

28

9-89

Location

Loc Qty

Loc Code

ST011

6

65085

6

107611

D2569

Hinge

Manufactured No

130 Each

2.0000

1

1

Location

Loc Qty

Loc Code

CA

2

94308

2

13107688 13-01-03

D3001-1

Doubler

Manufactured No

110 Each

7.0000

3

3

Location

Loc Qty

Loc Code

ST178

7

85393

1

99490

6

1 C213/10/02  
2X B 107795

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Page 3

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Thursday, September 26, 2013 10:06:39 A

Page 4

Work Order ID: 107494

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/26/2013

Required Date: 10/4/2013

Start Qty: 1.00

Required Qty: 1.00

D3007-041	Manufactured	No	130	Each	2.0000	1	1	DAS 28 9-89	13-12-27
Prop Assy									
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
			ST259		1				B107599
			84300		1				
			ST265		1				
			99639		1				
D3048-1	Manufactured	No	110	Each	0.0000	1	1		B 100618 C213/10/02
Doubler									
MS21042L06	Purchased	No	100	Each	351.0000	2	2		
Nut									
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>		DAS 28 9-89	
			ST314		216				
			124859		16				
			m126474		200				2X
			ST316		135				
			125303		135				
MS21042L4	Purchased	No	130	Each	3,608.0000	20	20		
Locknut								DAS 28 9-89	
			<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001		50				127376
			122452		38				
			8182		12				
			ST314		9				
			m125708		9				
			st507		33				
			m126073		33				
			ST509		3093				
			m126275		3093				
			ST510a		258				
			m126333		258				
			ST518		165				
			124231		165				

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Page 4

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Thursday, September 26, 2013 10:06:39 A

Page 5

Work Order ID: 107494

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/26/2013

Required Date: 10/4/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN632J

Purchased

No

130

Each

565.0000

2

2

DAS

28

9-89

Washer

13-12-27

Location

Loc Qty

Loc Code

ST293

554

123900

5

M126084

543

M126254

6

ST510a

11

125646

11

2x

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Page 5

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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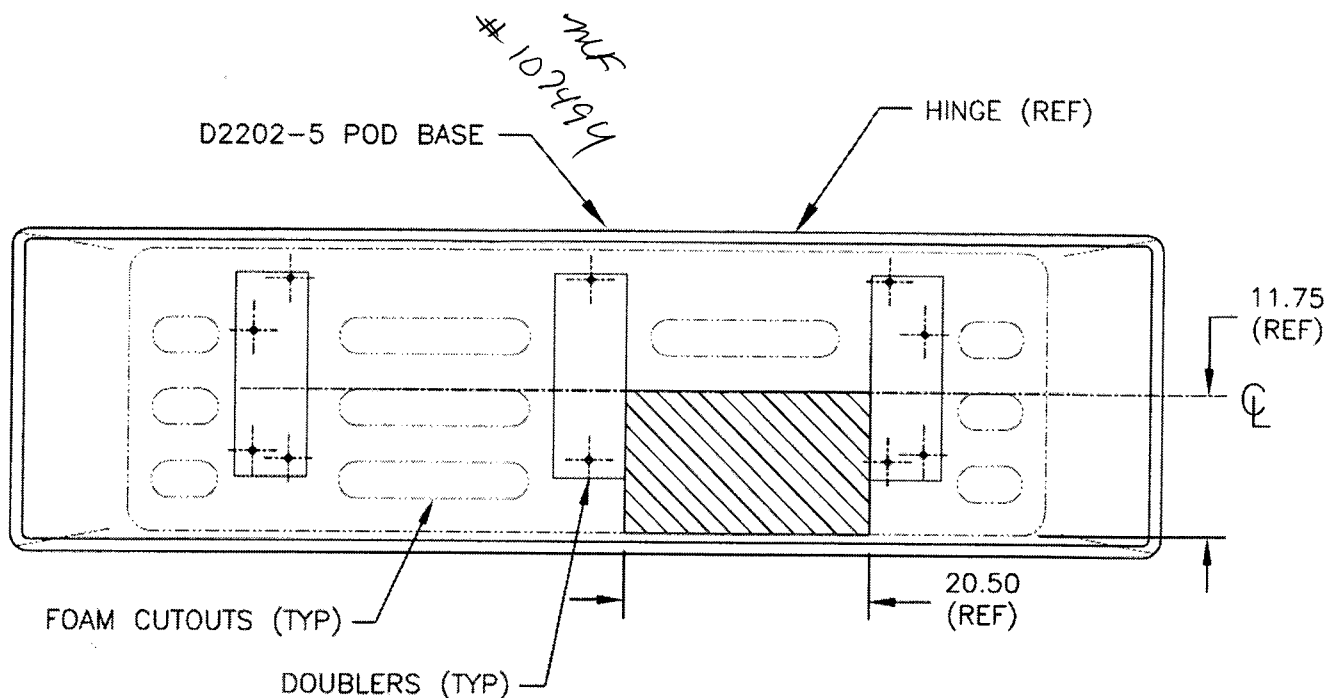


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

RELEASED  
04.10.29 *#*

**D3322-041/-042 POD ASSEMBLY**

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE



D3322-041 POD ASSEMBLY (SHOWN)  
D3322-042 POD ASSEMBLY (OPPOSITE)

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**NOTES:****1) MATERIALS:**

RESIN: EPOCAST 50-A/9816,  
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,  
OR DIVINYCELL,  
OR AIREX,  
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2  
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.  
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

CZ13109/27

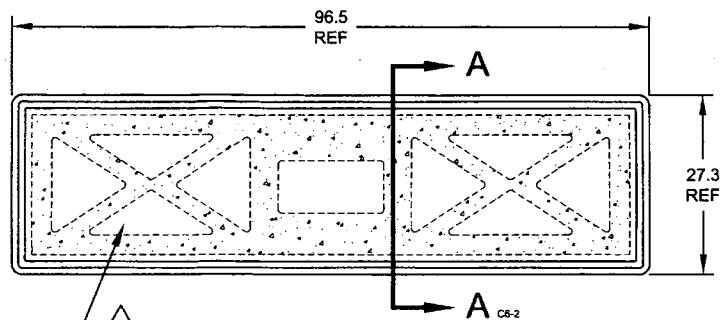
W10: 107494

RELEASED  
R 2010-10-28

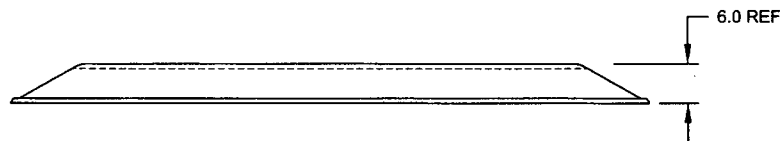
G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	103	TITLE	SCALE
DE APPR.	11	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SEE  
DETAIL B  
A6-2

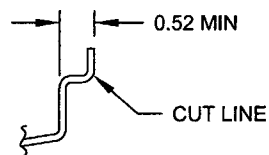
SECTION A-A C3-2



D2202-101 FOAM CORE,  
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



**D2202-1 LID**  
(MOLD DT8002)



DETAIL B  
SCALE 10X D6-2

**MAIN LAYUP**

9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-101 FOAM CORE  
5oz KEVLAR  
9oz SATIN

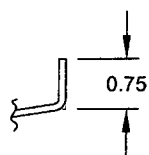
**RELEASED**  
2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D2202	REV. G SHEET 2 OF 5
MFG. APPR.	JM	TITLE	SCALE
APPROVED	JP	UTILITY POD LID AND BASE	NTS
DE APPR.	JP	COPYRIGHT © 1993 BY DART AEROSPACE LTD	
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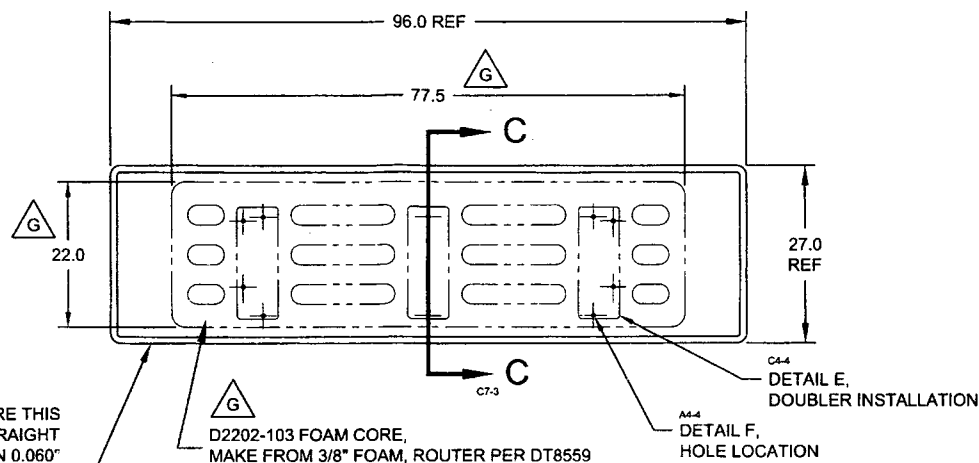
SEE  
DETAIL D  
B7-3

**SECTION C-C** C4-3

ENSURE THIS  
EDGE IS STRAIGHT  
WITHIN 0.060"  
AFTER TRIMMING



**DETAIL D**  
SCALE 10X  
D7-3

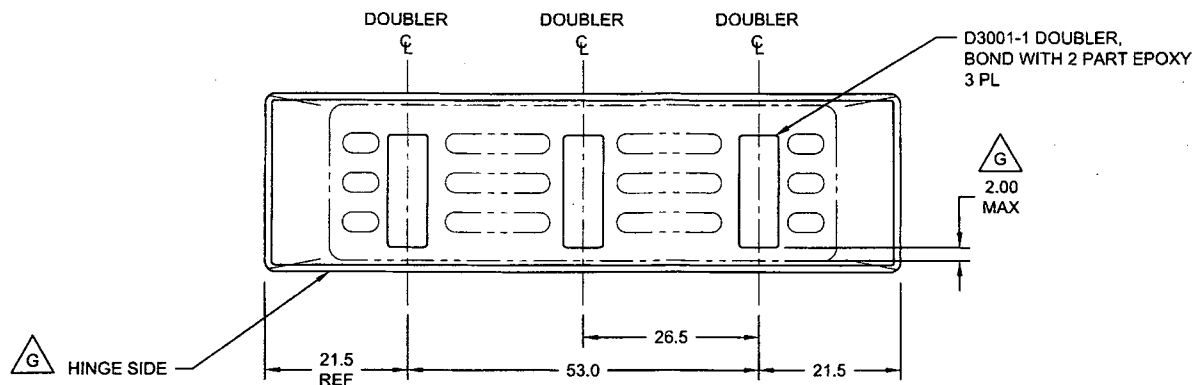


**D2202-3 BASE**  
(MOLD DT8002)

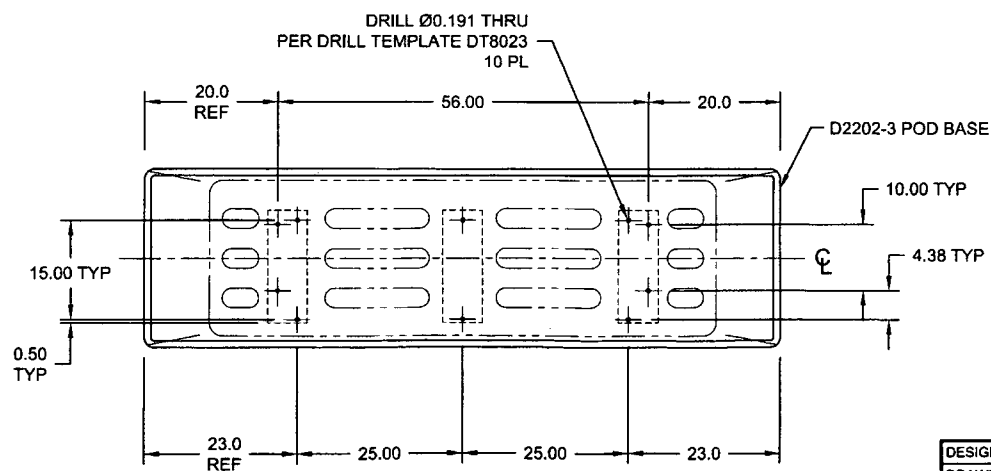
**MAIN LAYUP**  
9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-103 FOAM CORE  
5oz KEVLAR  
5oz KEVLAR  
9oz SATIN

**RELEASED**  
2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
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**DETAIL E: INSTALLATION OF D3001-1 DOUBLERS** C3-3



**DETAIL F: HOLE DRILLING** C3-3  
(AFTER DOUBLER INSTALLATION)

**RELEASED**  
R 2010-10-28

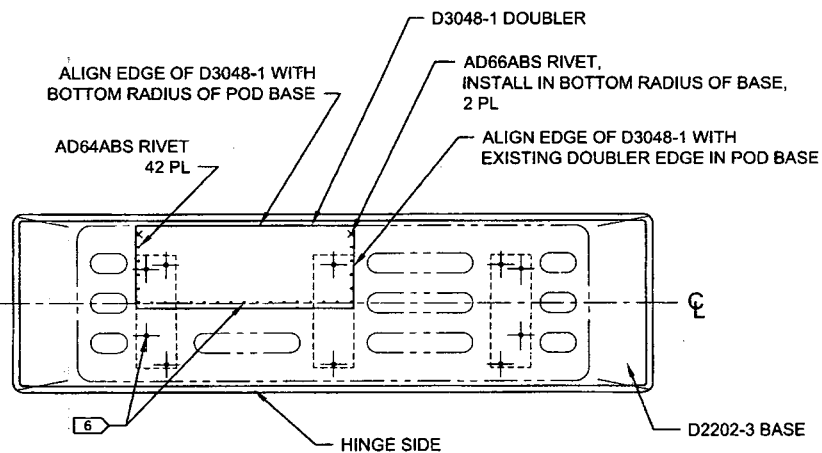
DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	17	TITLE	SCALE
DE APPR.	17	UTILITY POD LID AND BASE	NTS
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**NOTES : TO MAKE A D2202-5/6 BASE (FOR D350-602-013/014) FROM A D2202-3 BASE**

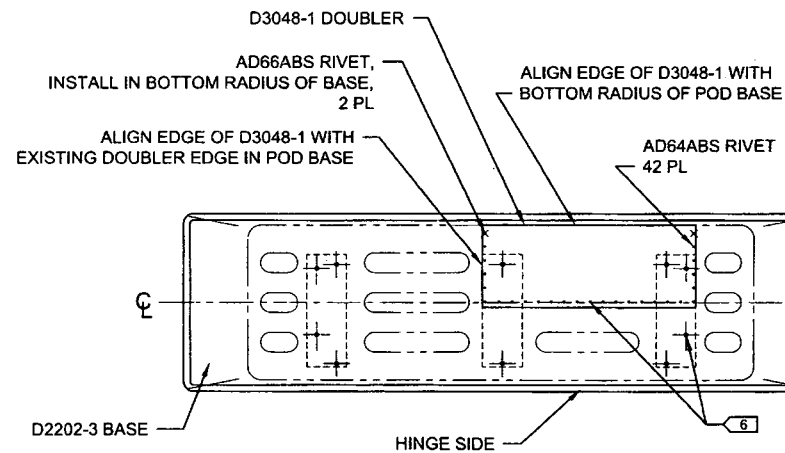
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

**PART LIST:**

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



**D2202-5 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)



**D2202-6 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)


DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	19	TITLE	SCALE
DE APPR.	19	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
R 2010-10-28

Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

Feuille de Procédé

4/ 14 oct

Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD LID
Numéro Job	: 56326	Numéro Article	: DKC134-0073
Numéro	: 4347	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2013-10-08 No. :	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - -	Date Dûe	: 2013-11-11 Qté: 1 Ud UNITE
Job précédente	: 55564		
Écrit par	: 		
Vérifié & Approuvé par	:		
Commentaires	: N° de Pièce Client: D2202-1		

Process Sheet Rév.: 03 Ajout de la IF134-0008 à la séquence 35.0.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 27/11/13 Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-43047-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-2829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le gel coat selon IG 0019.

Date: 27/11/13 Sceau:

449 D.B.





Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56326

Nom Dessin: UTILITY POD LID  
Numéro DKC134-0073

Numéro Job:



# Séq.: Machine ou Opération:

Description :

6.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)  
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-41291-1 et 1-43410-1

7.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)  
Tissu à délaminer Release ply B

# de Lot: N/A

8.0 AAC1608 5oz plain weave Kevlar 50" wide roll

Comment Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)  
5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-42765-3

9.0 AAC1887 Wrightlon 5200 Bleu P3

Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)  
Wrightlon 5200 Bleu P3

# de Lot: N/A

10.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

12.0 AC0886 Ruban à gommer jaune #: T/IAT-200Y

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

13.0 TAILLAGE Faire le taillage du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide ( Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply

Film Durisol P-3

Feutre de drainage 6m

Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Date: Mardi, 2013-10-08 14:23:20

Utilisateur: Mario Chantal

**Feuille de Procédé**

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 56326

Numéro DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 22-11-13 Sceau: 4499-D.B.

14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-4387-1

15.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

16.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid :  
1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Date: 28/11/13 Sceau:



17.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des trois premiers plis de tissu ( 2 plis de 9 oz et 1 pli de 5 oz Kevlar )  
de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350  
Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre  
avec les deux extrémités et terminer avec les deux cotés. ( Ajouter de la résine au besoin  
)

Recommencer pour les deux autres plis. ( un pli de 9 oz et un pli de 5 oz Kevlar )

Date: 28/11/13 Sceau:

4460 R.L. 4499 D.B.



18.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher 4 heures minimum

Date: 28/11/13 Sceau:

4460 R.L. 4499 D.B.



Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56326

Nom Dessin: UTILITY POD LID  
Numéro DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

19.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-4387-1

20.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 DKC134-0022

D2202-101 Foam Core ( Utility Pod Lid )

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
D2202-101 Foam Core ( Utility Pod Lid ) N° de Job: 56460

22.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst  
DDM-9 par quantité de résine.

Date: 28/11/13 Sceau: 4460 R.L.

23.0 ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0022 selon IG 0105.

Date: 28/11/13 Sceau: 4460 R.L.

24.0 AAC1611

Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)  
Polybond B46F N° de Lot: 1-40592-1

25.0 ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG  
0033.

Date: 29/11/13 Sceau: 4499 DB



26.0 BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56326

Nom Dessin: UTILITY POD LID  
Numéro: DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 1:30

Heure Fin Curing: 2:45

Date: 2/11/13 sceau: 4499DB



27.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-43767-1

28.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

29.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod  
Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

Date: 2/12/13 Sceau:



30.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des deux dernier plis de tissu ( 1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. ( Ajouter de la résine au besoin )

Recommencer pour le dernier plis. ( un pli de 9 oz )

Date: 2/12/13 Sceau:

4499DB



Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56326

Nom Dessin: UTILITY POD LID  
Numéro DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

31.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher 4 heures minimum.

Heure début Curing: 10:30

Heure Fin Curing: 8:00

Date: 2/12/13

Sceau: 4499 DB



32.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la pièce

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.

Date: 3/12/13

Sceau: 4499 DB



33.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: \_\_\_\_\_

34.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munie d'une aiguille de la résine au endroit où il y a des bulles d'air.

Corriger les imperfection de surface à l'aide du "Filler" P15-3 selon IG 0043

Laisser sécher jusqu'au lendemain.

Date: 03-12-13

Sceau: 4499 DB

0.0

Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56326

Nom Dessin: UTILITY POD LID  
Numéro DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

35.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le trimage du Pod Lid selon la IF134-0008.

Date: 3/12/13 Sceau:



36.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-43178-2

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1

38.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Date: 5/12/13 Sceau:



# Fiche de Mélange: 6522

39.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes.

Date: 06-12-13 Sceau: 4499 23

40.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-43178-2

41.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1

42.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

11/12/13  
Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Date: 9/12/13 Sceau:



# Fiche de Mélange: 6522

Date: Mardi, 2013-10-08 14:23:20  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56326

Nom Dessin: UTILITY POD LID  
Numéro DKC134-0073

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

43.0

INSPÉC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Refuse → finition  
10 Dec 13  
IV

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 12 Dec 13 Sceau:



44.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 12-11-13 Sceau: L12181






Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal

## Feuille de Procédé

4 / 21 OUT

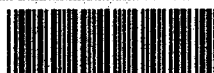
Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD BASE
Numéro Job	: 56327	Numéro Article	: DKC134-0075
Numéro	: 4345	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2013-10-08 No. :	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - - Type :	Date Dûe	: 2013-11-18 Qté: 1 Ud UNITE
Job précédente	: 44976		
Écrit par	: 		
Vérifié & Approuvé par	: _____		
Commentaires	: N° de Pièce Client: D2202-5		

Process Sheet Rév.: 02 AAC1885 était AC0883,  
AAC1887 était AC0884

COPIE

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo


Comment Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IF134-0011.

Date: 20/11/13 Sceau: 4499 D.B. 

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total : 1.250 KILOGRAMME(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-43097-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------


Comment Qty.: 0.0095 GALLON(s)/Unit Total : 0.0095 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs






Appliquer le Gel Coat sur le moule selon IF134-0011.

Date: 20/11/13 Sceau: 4499 D.B. 

Date: Mardi, 2013-10-08 14:23:21

Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: UTILITY POD BASE	
Numéro Job: 56327		Numéro DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)		N° de Lot: 1-43410-1	
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish			
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)		# de Lot: N/A	
Tissu à délaminer Release ply B			
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll	
Comment Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)		N° de Lot: 1-42765-3	
5oz plain weave Kevlar 50" wide roll			
9.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)		# de Lot: N/A	
Wrightlon 5200 Bleu P3			
10.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)			
11.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)			
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)			
13.0	AC1091	Film durisol # 3001792	
Comment Qty.: 12.50 METRE CAR(s)/Unit Total : 12.50 METRE CAR(s)			
14.0	TAILLAGE	Faire le taillage du matériel	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le taillage du matériel et le matériel pour le Bagging selon IF 134-0011.			
Date: 20/11/13 Sceau: 4499 D.B.			
15.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)		N° de Lot: 1-43187-1	
Résine (411B7530) 411-350 promo. 75min.			
16.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)		N° de Lot: 1-27829-1	
Catalyst N° DDM-9			
17.0	LAMINAGE	Faire le laminage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le laminage des tissus(verre et Kevlar) selon IF134-0011.			
Date: 21/11/13 Sceau: 4460 R.L. 4499 D.B.			



Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal

## Feuille de Procédé

Cliant: DART US DART AEROSPACE  
Numéro Job: 56327

Nom Dessin: UTILITY POD BASE  
Numéro DKC134-0075

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

18.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 8:30

Heure Fin Curing: 2:00

Date: 21/11/13

Sceau: 4460 R.L. 4499 D.B.



19.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-43187-1

20.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0

DKC134-0021

D2202-103 Foam Core ( Utility pod Base )

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
D2202-103 Foam Core ( Utility pod Base ) N° de Job: 56459

22.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0021 selon IG 0105.

Date: 20/11/13

Sceau: 4460 R.L.

23.0

AAC1611

Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)  
Polybond B46F N° de Lot: 1-40597-1

24.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011.

Date: 22/11/13

Sceau: 4460 R.L. 4499 D.B.





Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56327

Nom Dessin: UTILITY POD BASE  
Numéro: DKC134-0075

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

25.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 9:20

Heure Fin Curing: 10:45

Date: 22/11/13

Sceau: 4460 R.L. 4499 D.B.



26.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la découpe manuelle du foamcore selon IF134-0011 point 8.5.

Date: 22/11/13

Sceau: 4460 R.L. 4499 D.B.



27.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-43187-1

28.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

29.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des derniers tissus selon IF134-0011.

Date: 25/11/13

Sceau: 4460 R.L. 4499 D.B.



30.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 10:50

Heure Fin Curing: 8:00

Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56327

Nom Dessin: UTILITY POD BASE  
Numéro: DKC134-0075

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 25/11/13 Sceau: 4460 R.L. 4499 D.B.



31.0 AAC1615

D3001-1 Doubler ( Pod Base D2002-3)

Comment Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)  
D3001-1 Doubler ( Pod Base D2002-3)

N° de Lot:

1-43248-1

32.0 AAC0102

Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)  
Colle Araldite N° 2012 (50ml)

N° de Lot:

1-40931-3

33.0 ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller les trois doubliers N° D3001-1 selon IF134-0011.

Faire trois petites poches à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing:

9:45

Heure Fin Curing:

2:00

Date: 26/11/13

Sceau:

4460 R.L.



34.0 AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler

# de Lot:

1-43091-1

35.0 FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Retirer les trois poches à vide et faire un joint tout autour des trois doubliers à l'aide du "Filler" P15-3 et laisser sécher.

Date: 26/11/13

Sceau:

4460 R.L.



36.0 AAC1680

D3048-1 Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
D3048-1 Doubler

N° de Lot:

1-43248-2

37.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.

Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 56327

Nom Dessin: UTILITY POD BASE  
Numéro DKC134-0075

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Date: 26/11/13 Sceau: 4460 RZ



38.0 AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total: 0.060 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-43091-1

39.0 FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la finition de l'intérieur selon IG 0043.

Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munie d'une aiguille de la résine aux endroits où il y a des bulles d'air.

Corriger les imperfections de surface à l'aide du "Filler" P15-3.

Laisser sécher jusqu'au lendemain.

Date: 28/11/13 Sceau: 4499 DZ

40.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce.

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis.

Date: 27/11/13 Sceau: 4499 DZ



41.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs


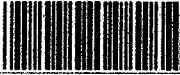










Faire le trimage selon IF134-0012.

Date: 27/11/13 Sceau: 4499 DZ



Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal








## Feuille de Procédé

Client:	DART US DART AEROSPACE		Nom Dessin:	UTILITY POD BASE	
Numéro Job:	56327		Numéro	DKC134-0075	
Numéro Job:					
# Séq.:	Machine ou Opération:	Description :			
42.0	AAC1021	Dupont Primer N° 7704S			
Comment	Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-42451-1</u>				
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase			
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-40909-1</u>				
44.0	PRÉPARATION.	Préparation du matériel			
					
Comment	Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  Préparer la pièce selon IG 0008.  Date: <u>28-11-13</u> Sceau: <u>4499-2.B</u>				
45.0	PRIMER	Application primer			
					
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Préparer et appliquer le primer selon IG 0008.  Date: <u>29/11/13</u> Sceau:  # de Fiche technique: <u>6516</u>				
46.0	FINITION	Finition Générale			
					
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Ponçer le "Primer" batisseur selon IG 0008.  Date: <u>2/12/13</u> Sceau: <u>4499 D.B</u> 				
47.0	AAC1021	Dupont Primer N° 7704S			
Comment	Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43178-2</u>				
48.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase			
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-40909-1</u>				
49.0	PRIMER	Application primer			
					
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Préparer et appliquer le primer selon IG 0008.  Date: <u>5/12/13</u> Sceau:  Fiche: <u>6521</u>				



Date: Mardi, 2013-10-08 14:23:21  
Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: UTILITY POD BASE	
Numéro Job: 56327		Numéro DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
50.0	INSPÉC FINAL	Inspection finale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.			
Date: 10/12/13 Sceau: 			
51.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Emballer et entreposer selon IG 0057.			
Date: 10-12-13 Sceau: 			

Qty	Part Number	Description
X	D2694	UTILITY POD ASSEMBLY
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2481-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET

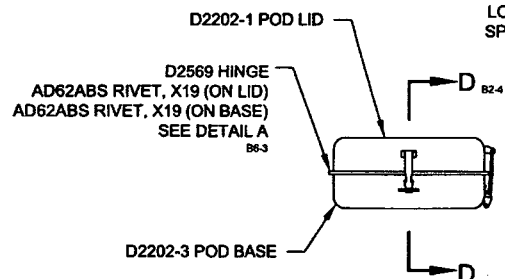
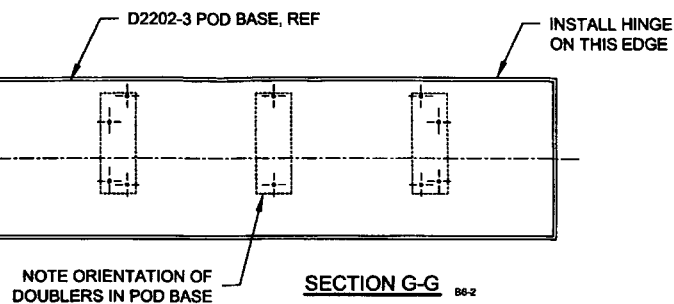
# **GENERAL NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER QSI 005 4.2 TO MATCH ORIGINAL FINISH  
AS REQ'D TO TOUCH UP FINISH AFTER DRILLING OR ASSEMBLY  
INSIDE: DUPONT HIGHBUILD PRIMER GREY 1144-S  
OR DUPONT 2K-URETHANE PRIMER GREY 7704-S  
OUTSIDE: DUPONT IMRON POLYURETHANE ENAMEL BASE WHITE (555U)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 48.5 lbs
- 8) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141  
AN4 → DRILL Ø0.257
- 9) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- 10) FOR D2569 HINGE:
  - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD
  - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
  - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A

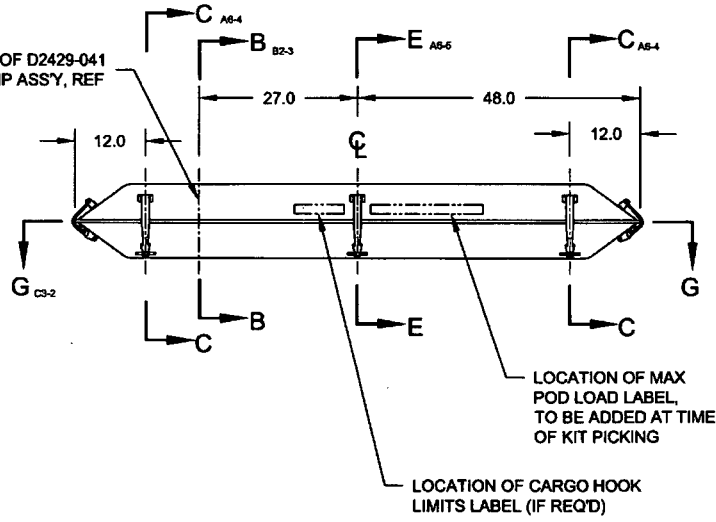
**RELEASED**  
2010-04-29

I	REFORMAT, D2204-9 LOC SPEC'D (B2-4,B6-4,C2-4,C6-4, B6-5,C6-5), D2461-X WAS D2462-X (D5-1,B1-2), ADD FINISH (B5-1)	CP	10.04.20
H	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	DC	07.07.18
G	REVERT BACK TO D2204-9 LATCH	CP	01.05.08
F	REDESIGN, CHANGE LATCHES & PROP	CP	01.03.20
E	CHANGE DIMENSIONS	RF	99.12.20
D	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	CP	99.01.08
C	ADD DOUBLER HOLES, REMOVE FINISH	KE	98.11.12
B	CHANGE RIVET PATTERN, ADD D2429	KE	97.10.08
A	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	KE	97.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	AK	DRAWING NO.	REV. I
MFG. APPR.	AK	D2694	SHEET 1 OF 5
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

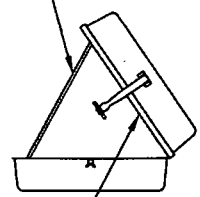




LOCATION OF D2429-041  
SPRING CLIP ASSY, REF



D3007-041 PROP ASSY,  
SEE SECTION E & F A6-5, B5-5



B102517  
D2461-1700 NEOPRENE SEAL,  
INSTALL ALONG TOP INSIDE EDGE OF  
LID (USE CONTACT CEMENT) ⚠

**D2694 UTILITY POD ASSEMBLY**

**RELEASED**  
2010-04-29  
MH

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. 1
MFG. APPR.	JP	D2694	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

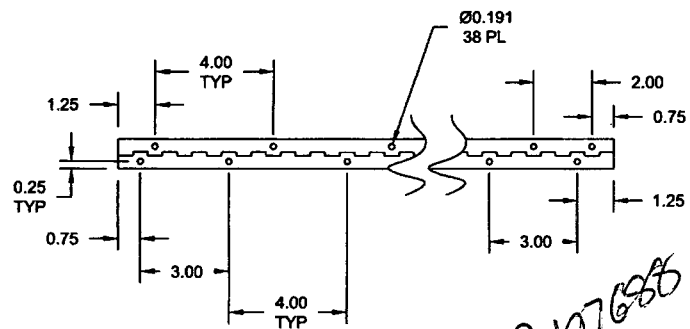
8 7 6 5 4 3 2 1

D

C

B

A



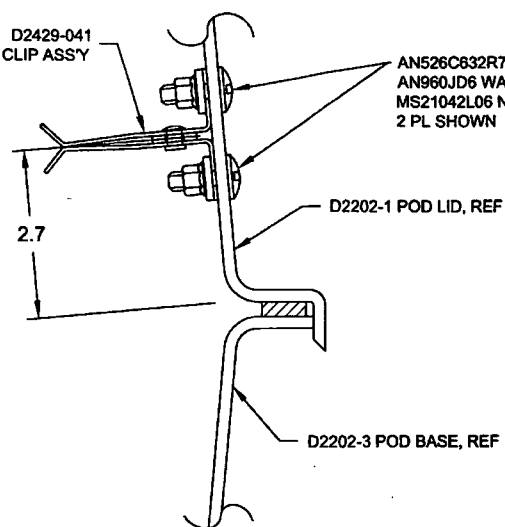
**DETAIL A: HINGE**  
NOT TO SCALE

10  
C7-2

D2429-041  
SPRING CLIP ASS'Y

AN526C832R7 SCREW  
AN960JD6 WASHER  
MS21042L06 NUT,  
2 PL SHOWN

8



**SECTION B-B**  
NOT TO SCALE

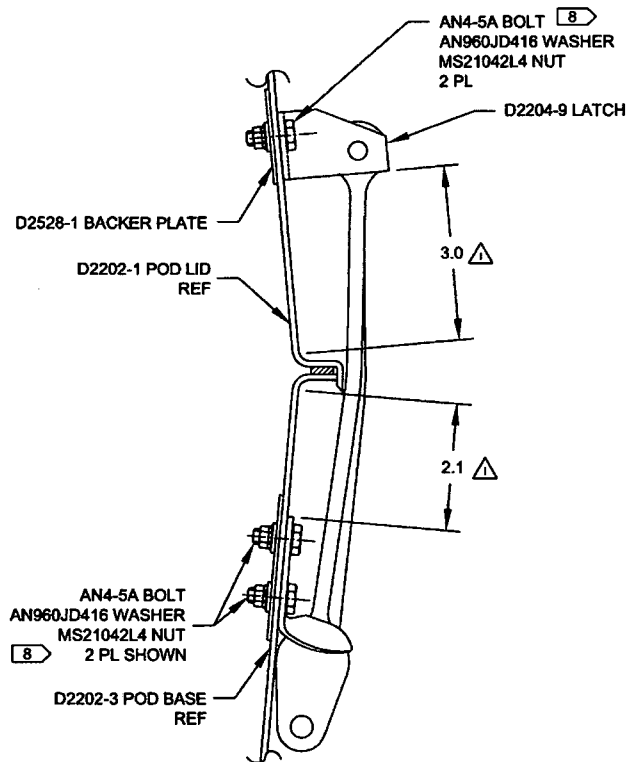
C5-2

**RELEASED**  
2010-04-29  
MP

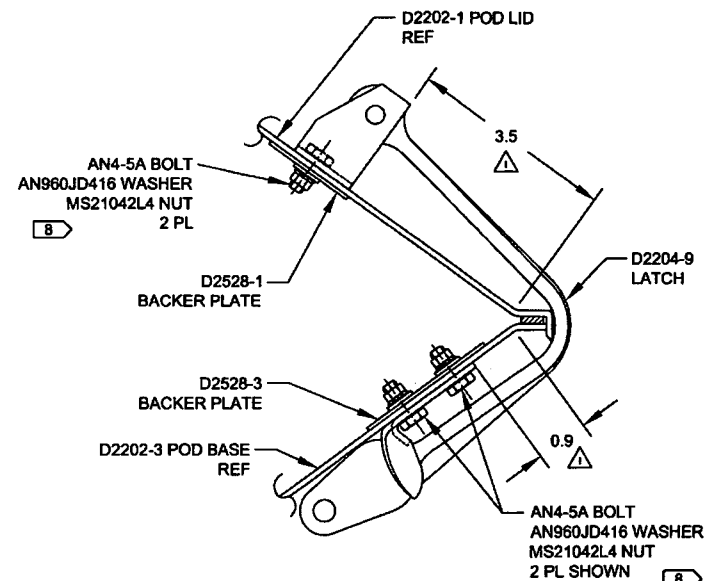
DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. 1
MFG. APPR.	JP	D2694	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NTS
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8 7 6 5 4 3 2 1





SECTION C-C C3-2, C5-2  
SCALE 10X



SECTION D-D C6-2  
SCALE 10X

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2010-04-29  
JMP

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DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. 1
MFG. APPR.	JP	D2694	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
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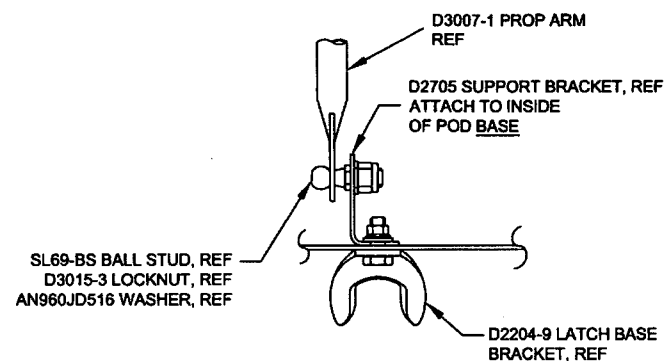
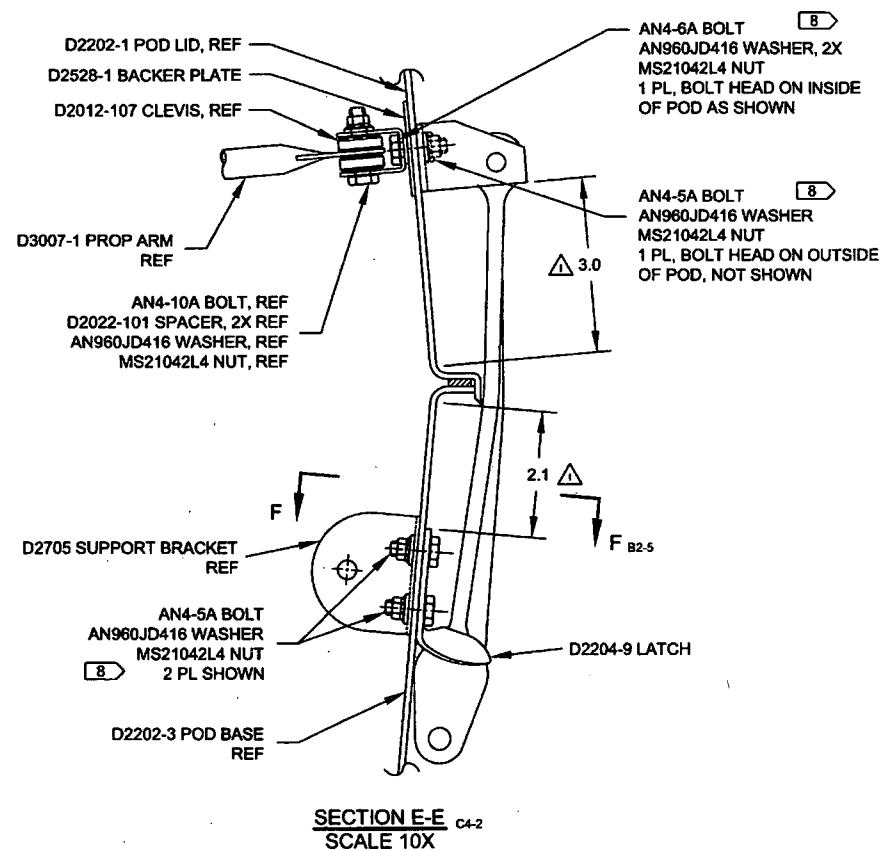
8 7 6 5 4 3 2 1

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2010-04-29

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DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D2694	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

**NOTES:****1) MATERIALS:**

RESIN: EPOCAST 50-A/9816,  
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,  
OR DIVINYCELL,  
OR AIREX,  
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

**2) FINISH:** INSIDE = PRIME PER DART QSI 005 4.2  
OUTSIDE = WHITE GELCOAT #GEL 944W005

**3) TOLERANCES:** PER DART QSI 018 UNLESS OTHERWISE NOTED

**4) UNITS:** INCHES UNLESS OTHERWISE NOTED

**5) BREAK SHARP EDGES:** 0.005 TO 0.010 MAX

**6) IDENTIFICATION:** NONE

**7) WEIGHT:** N/A

**8) LAMINATE PER DART QSI 006.**  
LAMINATION SCHEDULE PER THIS DRAWING.

**9) PEEL PLY ALL SURFACES.**

**RELEASED**  
2010-10-28

G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH UP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

